



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D4151-5
Job Sheet 186914



Part No: D4151-5

Job Qty: 20 ea *24ea*

Part Name: Fwd Basket Instl Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		12/7/18	0.00	0.00	Start Up Machining-2		
110	Doosan	20 pcs		12/7/18	0.01	6.41	Doosan		
130	QC	20 pcs		12/7/18	0.00	0.00	QC8		
140	Packaging	20 pcs		12/7/18	0.00	0.00	Packaging3-2		
150	QC21-SA	20 Ea		12/7/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Mill as per folio FA953 & dwg ,

DAS
21
0-89

DEC 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	5 ft (25 ea)	90-Start up Operation	5123402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R1.000	5	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Basket Inst. Stud (Lower)	1.000Inches ± 0.030	1.030 0.970	Diameter	1.00
2	Fwd Basket Inst. Stud (Lower)	0.800Inches + 0.000 - 0.010	0.800 0.790		795
3	Fwd Basket Inst. Stud (Lower)	0.750Inches + 0.030 - 0.000	0.780 0.750		760
4	Fwd Basket Inst. Stud (Lower)	0.375Inches ± 0.010	0.385 0.365		3755
5	Fwd Basket Inst. Stud (Lower)	0.500Inches ± 0.030	0.530 0.470		492
6	Fwd Basket Inst. Stud (Lower)	1.000Inches + 0.003 - 0.000	1.003 1.000		1.0015
7	Fwd Basket Inst. Stud (Lower)	2.000Inches ± 0.030	2.030		1.999

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

			1.970	
8	Fwd Basket Inst. Stud (Lower)	2.880Inches ± 0.030	2.910 2.850	2.875
9	Fwd Basket Inst. Stud (Lower)	0.250Inches ± 0.010	0.260 0.240	.240
10	Fwd Basket Inst. Stud (Lower)	0.438Inches $+ 0.000$ $- 0.010$	0.438 0.428	Diameter .434
11	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	.125
12	Fwd Basket Inst. Stud (Lower)	0.060Inches ± 0.030	0.090 0.030	Radius R 1/16
13	Fwd Basket Inst. Stud (Lower)	0.250Inches $+ 0.003$ $- 0.000$	0.253 0.250	Diameter .2515
14	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	Radius R 1/8

Plex 11/22/18 1:16 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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